

Date: Monday, 11/28/2005 10:24:46 AM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM WELDMENT
Job Number :	24755	Part Number :	D33791
Estimate Number :	10459	Drawing Number :	D3379 REV C
P.O. Number :	N/A	Project Number :	N/A
This Issue :	11/28/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Revision :	C
First Issue :	N/A	Material :	N/A
Previous Run :		Due Date :	12/5/2005
Written By :	See Comment below		
Checked & Approved By :	See Comment below		
Comment :	Est Rev:A 05.02.03 New-issue KJ/JLM		

Qty: 5 Upr Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010B1000X02000	1010-1025 Steel Bar
-----	------------------	---------------------



Comment: Qty.: 0.3281 f(s)/Unit Total 1.6406 f(s)
Material: 1010-1025 Steel Bar
(M1010-B1.000x02.000)
Identify for D3379-1
Batch: M 7731

SA 05.12.03

405
382

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank: 2.00" x 1.00" x 3.750" long

SA 05.12.03

5+1

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA502 and Dwg D33792-
2- Identify as D3379-1
3-Deburr

SA 05.12.04 (5)

PTO
last page

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 05.12.04 (5)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 05.12.04 (5)

Date: Monday, 11/28/2005 10:24:46 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM WELDMENT

Job Number: 24755

Part Number: D33791

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 421

5/12/05

(5)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5/12/06

(5)

(5)

05/12/06

(5)

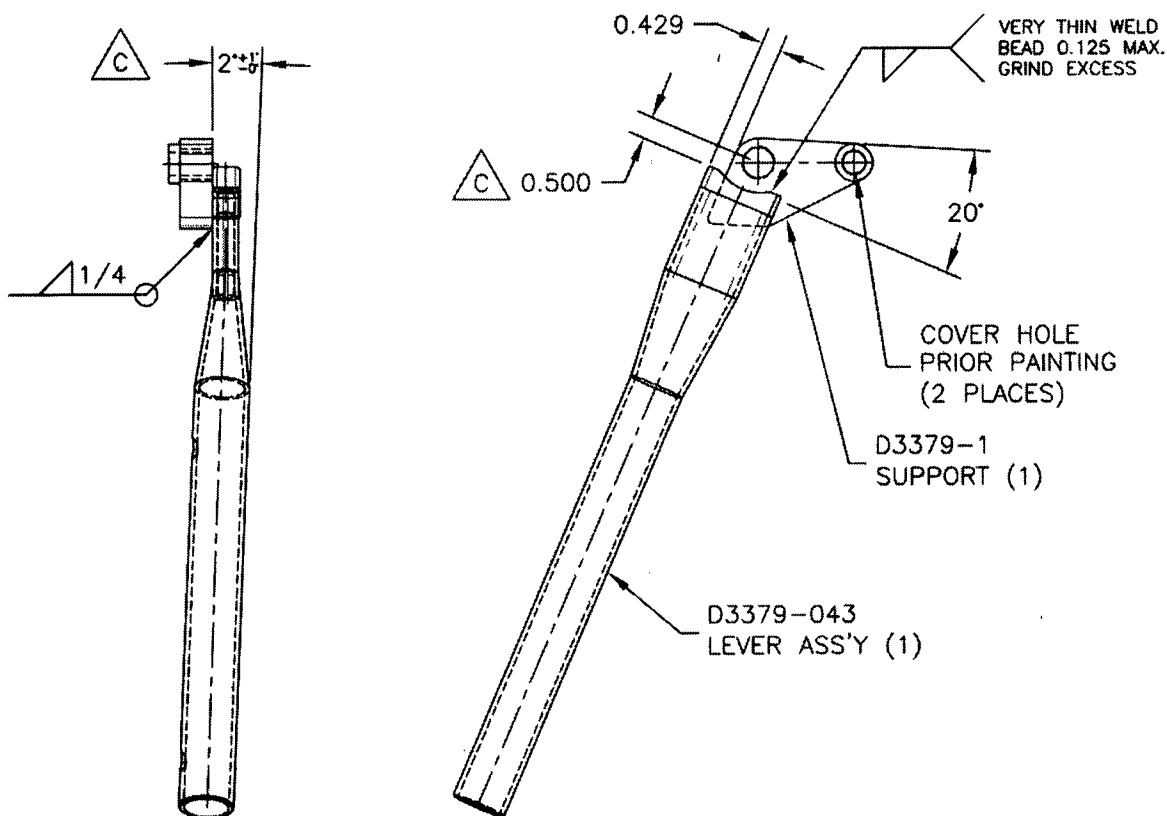
Job Completion



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3379	REV. C SHEET 1 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:1
A	04.12.13	NEW ISSUE	
B	05.02.25	RE-DESIGN D3379-5	
C	05.05.27	2" WAS 4"; UPDATE DIMENSIONS	

RELEASED
as of 10/05



D3379-041 ARM WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3379-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF 4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

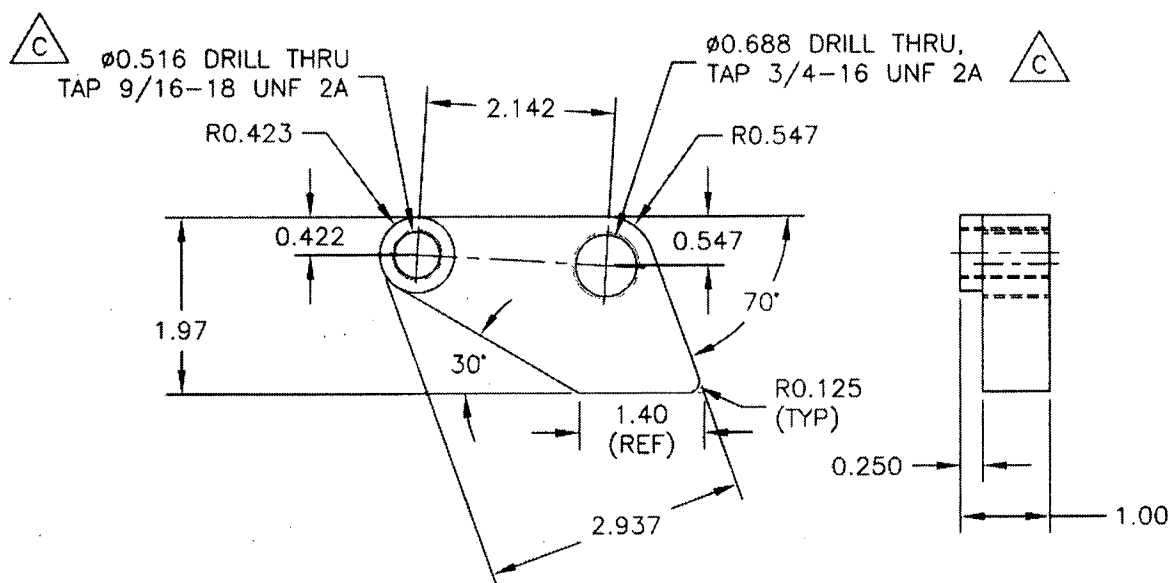
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 2 OF 4
DATE 05.05.27		TITLE ARM WELDMENT	SCALE 1:2

RELEASED
[Signature]
05/07/05



D3379-1 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.000 STEEL (REF. DART SPEC. M1010-B1.000x02.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

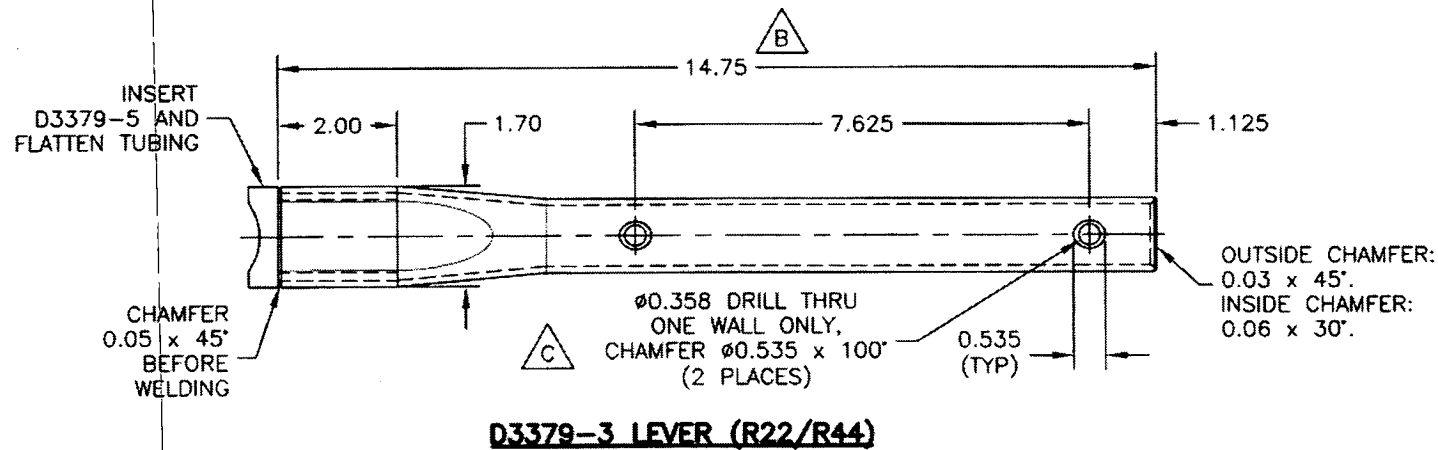
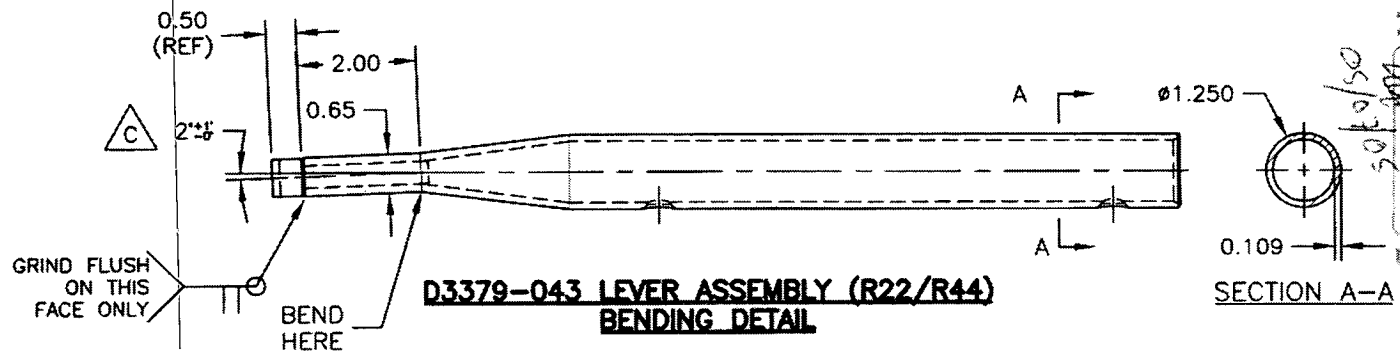
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3379	SHEET 3 OF 4
05.05.27		TITLE	SCALE
		ARM WELDMENT	1:3

RELEASED
05/09/05



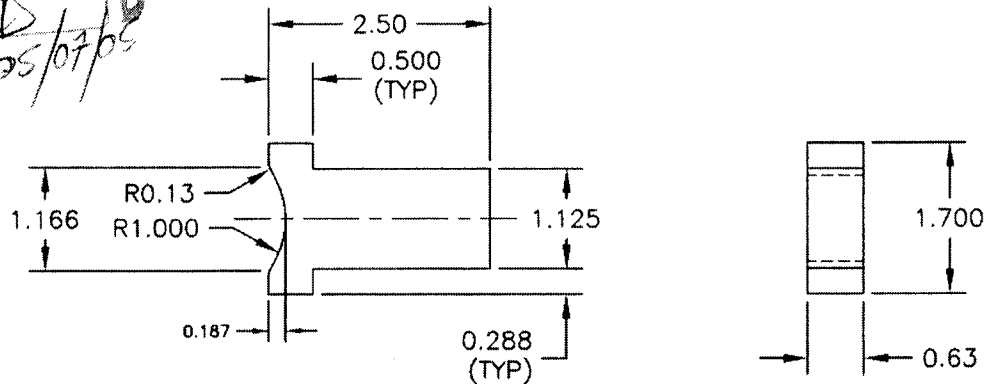
NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.250W.109)
- 2) WELD PER QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

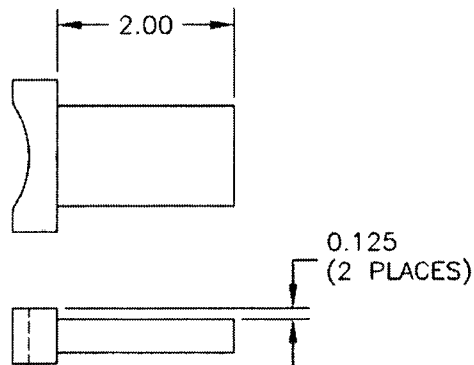
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3379	REV. C SHEET 4 OF 4
DATE 05.05.27	TITLE ARM WELDMENT		SCALE 1:1

RELEASED
[Signature]
05/07/05



D3379-5 LASER CUT PATTERN (R22/R44)



D3379-5 PLATE (R22/R44)

NOTES:


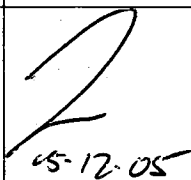

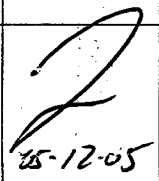
- 1) MATERIAL: 1010-1025 BAR MILD STEEL, 0.625 THICK
(REF. DART SPEC. M1010-B0.625)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/12/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.12.04	3	<p>4.688 hole o/s (1 part)</p> <p>Drill was unavailable.</p> <p>An endmill was used</p> <p>and the first program</p> <p>edit cut part off.</p>		<p>Re-edit program.</p> <p>Destroy + Replace</p>	<p>BSG</p> <p>05.12.04</p>	 <p>05-12-05</p>		 <p>05-12-05</p>

NOTE: Date & initial all entries